

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					A De							
					4	ALC:						
Part No:		PAR #: Fault Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date:										
NCR:		1	WORK ORDE	ER NON-CONFO	RMANCE	(NCR)	M.			7 118		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng			Verification Section C		Approval Chief Eng	Approval QC Inspector		
	1					hist						
					. 1, 2							

Date:

Monday, 18/08/2008 3:44:55 PM

User:

. Julie Lecocq

Process Sheet

33 Officer

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41367

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

00/12/23

21.0

DACKAGING 1

PACKAGING RESOURCE #1

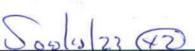


Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

welding



22.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/232

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CARC

NWF 08-10-23

Dart Aerospace Ltd

W/O:		Park '	WC	ORK ORDER CHANGES	DEVICE I				
DATE	STEP	PROC	The state of the s	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
32.						, roo mg			
See.									1
Part No	:	PAR #:	_ Fault Cate	gory: No				_ Date: _	
NCR:		W	ORK ORDE	ER NON-CONFORMANC					
DATE STEP		Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign 8	Verific Secti		Approval Chief Eng	Approval QC Inspector
	J					5		e diga	
					N.			100	
					71 -			100	

Date: Monday, 18/08/2008 3:44:55 PM User: Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY Job Number: 41367 Part Number: PB674300115 Job Number: Seq. #: Machine Or Operation: Description: START TIME: **OVEN TEMPERATURE** FINISH TIME: 14.0 QC3 INSPECT POWDER COAT/CHEMICA Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 15.0 PB674300173 20 Degree Cover Plate Comment: Qtv.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) 20 Degree Cover Plate batch: 415/ 16.0 PB674300183 PB67-43001-83 Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) PB67-43001-83 08-10-22 batch: 13 41 516 MS27039110 17.0 Screw Comment: Qtv.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s) Screw batch: __im 10903 08-10-22 NAS1149F0316P 18.0 WASHER Comment: Qty.: Total: 64.0000 Each(s) 8.0000 Each(s)/Unit WASHER batch: M10902 mr 08-10-22 19.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- match drill cover to existing holes in support 2- assemble as per dwg

Dart Aerospace Lt		Ltd									
W/O:		J. v. (1)		WC	RK ORDE	R CHANGES	No.				
DATE	STEP	-400	PR	ROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						-(6)					
C						75					10
),-											1
Part No	:		PAR #:	Fault Cate	gory:	N	CR: Yes	No DQ	A:	_ Date: _	
							QA: N	/C Close	d:	_ Date: _	11
NCR:			9	WORK ORDI	ER NON-CO	ONFORMANO	E (NCF	?)			716
4-		Description of NC	on of NC	Corrective Action Section B				Verific	ication	Approval	Approval
DATE	STEP		ion A	Initial Chief Eng	Action D	escription ef Eng	Sign 8 Date		ion C	Approval Chief Eng	QC Inspecto
	DC						1				

Section A Chief Eng Chief Eng Section C Chief Eng Chief

Monday, 18/08/2008 3:44:54 PM User: Julie Lecocq **Process Sheet** Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY Customer: CU-DAR001 Dart Helicopters Services Job Number: 41367 Part Number: PB674300115 Job Number: Seq. #: Machine Or Operation: Description: LARGE FAB 1 LARGE FABRICATION RESOURCE 1 6.0 Comment: LARGE FABRICATION RESOURCE 1 1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg VISUAL WELDING INSPECTION 7.0 QC9 08.09.29 Comment: VISUAL WELDING INSPECTION 8.0 QC5 INSPECT WORK TO CURRENT STEE Comment: INSPECT WORK TO CURRENT STEP MS124780 HELICAL INSERT Comment: Qty.: 8.0000 Each(s) 1.0000 Each(s)/Unit Total: HELICAL INSERT SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 10.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush in area of PB67-43001-249 only 08.09.29 2- install helicol insert as per dwg 11.0 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 13.0 POWDER COATING N 102316 Comment: POWDER COATING 1- MASK TUBE FROM BASE TO GUSSET m-1 08/09 2- Powder Coat Green Sandtex (Ref. 4.3.5.8) as per QSI 005 4.3 Page 2 Form: rprocess

Dart Aerospace Ltd

W/O:		the state of the	WO	RK ORDER CHANGE	S					
DATE	STEP	PI	ROCEDURE CHAP	EDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
i i		3 3 €			i e IL					
-			-			ľ				119
¢						á				
Part No	:	PAR #:	Fault Categ	jory:	NCR	: Yes	No DQ	A:	_ Date: _	
						QA: N	/C Close	d:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE	(NCR	2)			1
DATE	STEP	Description of NC		Corrective Action Section B			Verifi	cation	Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
	1								2	
							liè			
								4		

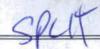
: FWD ADJUSTABLE BLADE SUPPORT ASSY

· PB674300115

· B6743001 P.7

: 18/09/2008

: N/A



User

Monday, 18/08/2008 3:44:54 PM*

Julie Lecocq

Process Sheet

Drawing Name

Part Number

Material

Due Date

Description:

Drawing Number

Project Number

Drawing Revision

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 41367 - 1

: 13433 **Estimate Number**

P.O. Number

This Issue : 18/08/2008 S.O. No. :

: NC Prsht Rev.

: 11 First Issue

: 40608 Previous Run

Written By

Checked & Approved By Comment

Type

08-06-26 new issue DD verified by:ec

: LARGE FAB ASSY

: Est Rev:A

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Inner Tube

8.0000 Each(s)

8.0000 Each(s)

8.0000 Each(s)

1.0

PB6743001257

1.0000 Each(s)/Unit Total:

Comment: Qty.:

Inner Tube

Inner Tube Bushing

Comment: Qty.: 1.0000 Each(s)/Unit Total:

Inner Tube Bushing

Comment: Qty.: 1.0000 Each(s)/Unit Total:

Gusset

4.0

Gusset

Comment: Qty.: 1.0000 Each(s)/Unit

Total:

8.0000 Each(s)

Gusset

PB67-43001-71

Comment: Qty.: 1.0000 Each(s)/Unit

Total: 8.0000 Each(s)

PB67-43001-71 batch:

Dart Aerospace Ltd.

Each



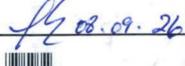






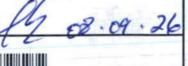














5.0